

Work Order ID 61783

Friday, September 03, 2010 10:11:57 AM



Page 1

Item ID: D3912-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyebolt Receiver Assembly

Start Date: 9/3/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

*M*Date: *10-9-03*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3912

B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

ES 10/11/19 (6)

110

0.00



Small Fab

Memo

0.00

Small Fab

1-Assemble D3912-1/-3/-5 and install rivets as per dwg
TRIM RIVETS 1.250" LONG

2- Install helical, spring plunger and spring pin lanyard assy as per dwg

ES 10/11/19 (6)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*Solving**(x6)*

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 9/3/2010 Start Qty: 6.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: S07

0.00



Packaging

Memo

0.00

Packaging

10/11/19
G

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 10/11/22
BT 10-11-19
G

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Picklist Print

Friday, September 03, 2010 10:12:03 AM

Page 1

Work Order ID: 61783

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly




Start Date: 9/3/2010

Required Date: 9/13/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: new issue DD 09.11.18 verified by:EC IPP Rev:B
10.06.10 memo in seq110 ***IF PLUNGER GOES IN TO DEEP, INSTALL A
WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND
D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO
FIT*** DD verf:JLM IPP REV:C AS PER REV B 10-08-05 JLM
VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3912-1  Eyebolt		Manufactured	No			100	Each	10.0000	1	6			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				FG095			4						
				61081			4						
				FG096			6						
				59441			6						
D3912-3  Eyebolt Block		Manufactured	No			100	Each	6.0000	2	12			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				ST096			6						
				59430			6						
D3912-5  Eyebolt Plate		Manufactured	No			100	Each	7.0000	2	12			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				ST096			7						
				61078			7						

EP 10/11/18
B63670 (4x)

EP 10/11/18
B61835 (10x)

EP 10/11/18
B61836 (9x)

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Page 2

Work Order ID: 61783

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Start Date: 9/3/2010

Required Date: 9/13/2010

Start Qty: 6.00

Required Qty: 6.00

D3801-1 Manufactured No



Hand Retractable-Spring Plunger

Each 16.0000 1



6
Ep 5/10/11/19

Location

Loc Qty

Loc Code

ST088

16

40736

2

56905

14

MS20615-4M20 Purchased No



RIVET

100 Each 266.0000 8



6
48
Ep 5/10/11/19

Location

Loc Qty

Loc Code

ST323

266

114808

96

115054

170

MS21209-F615 Purchased No



Heli-Coil

Each 97.0000 1



6
Ep 5/10/11/19

Location

Loc Qty

Loc Code

ST305

97

108170

76

108244

21

NAS1149F0332P Purchased No



WASHER

Each 599.0000 1



6
Ep 5/10/11/19

Location

Loc Qty

Loc Code

ST275

599

18057

599

6

Friday, September 03, 2010 10:12:03 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

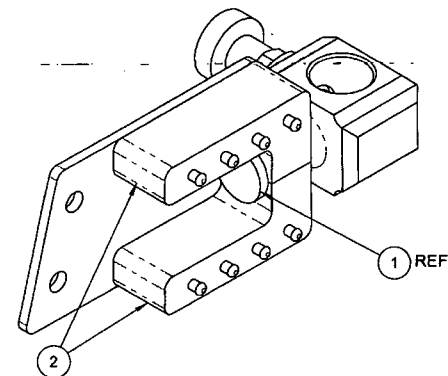
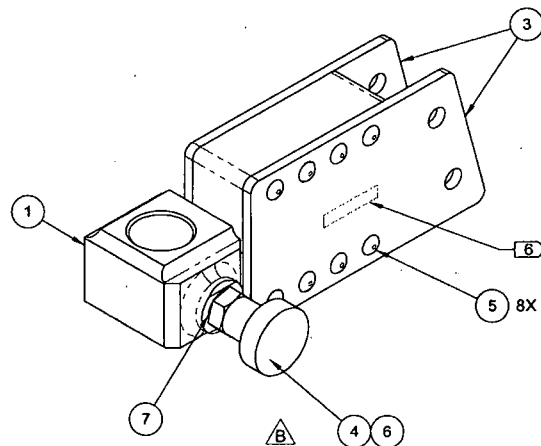
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ITEM	QTY	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20815-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41783

SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041: 1.58 lbs

RELEASED
2010-07-16

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV: MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0683R ADDED, BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>AJS</i>		
DRAWN	<i>JS</i>		
CHECKED	<i>JS</i>		
MFG. APPR.	<i>JS</i>		
APPROVED	<i>JS</i>		
DE APPR.	<i>JS</i>		
DATE	10.06.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3912** REV. B
SHEET 1 OF 3
TITLE **EYEBOLT RECEIVER ASSY** SCALE NTS

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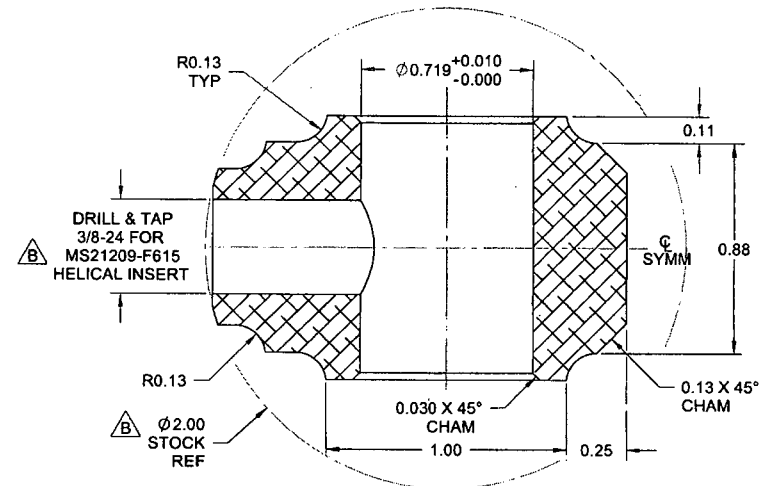
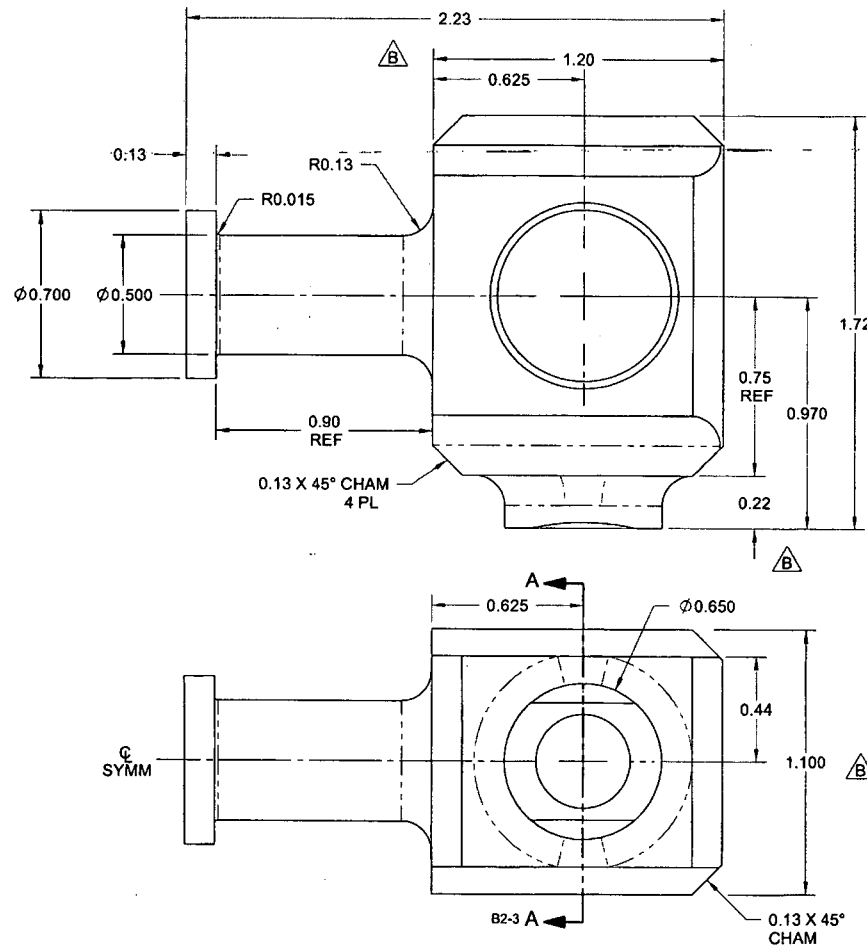
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SECTION A-A B6-3

RELEASED
2010-07-16

D3912-1 EYEBOLT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	JH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JH	DRAWING NO.	REV. E
MFG. APPR.	JH	D3912	SHEET 2 OF 3
APPROVED	JH	TITLE	SCALE
DE APPR.	JH	EYEBOLT RECEIVER ASSY	NTS
DATE	10.06.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O 41783

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2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ID AT ASSEMBLY
7) WEIGHT -3: 0.30 lbs
 -5: 0.24 lbs

RELEASE
2010-07-16

DESIGN	<i>AS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3912 TITLE EYEBOLT RECEIVER ASSY COPYRIGHT © 2010 BY DART AEROSPACE LTD. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONCEPTION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	REV. B
DRAWN	<i>AS</i>		SHEET 3 OF 3
CHECKED	<i>AS</i>		SCALE
MFG. APPR.	<i>AS</i>		NTS
APPROVED	<i>AS</i>		
DE APPR.	<i>AS</i>		
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